

Work Order ID 132731

Thursday, May 07, 2015 2:57:38 PM

132731

Page 1

Item ID: D2232-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Hinge
Start Date: 5/7/2015 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 5/7/2015 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: CY Date: MAR 08 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2232	Rev C								

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D2232 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

0.00

0.00

22ØJm15-5-11

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

22ØJm15-5-11

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

(22)DAS
38
9-85

MAY 11 2015

H-Form

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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N900040100

Setup Start *NS1*

Stop *NS2*

16

Cust Item ID:

16

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

130

Small Fab

Small Fab

Small Fab

~~Memo~~
~~Debur~~

DAS
38
9-89

0.00

0.00

140

140

Packaging

Packaging

Identify as per dwg & Stock Location: W H004

0.00

Memo

0.00

*****STOCK IN BASKET CELL*****
LOCATION : WA004

150

150

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

22 DL/15/5/12

MLJ

MAY 12 2015

ML5

MAY 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 132731

132731

Parent Item: D2232-3

D2232-3

Parent Item Name: Basket Hinge

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP B01.06.07Now laser cutEC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased		No		100	sf	194.4917	0.0694	1.168842			
										**	(2)	Jm 15-5-11	
304/316 0.125 Sheet													
			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>					
			MAT020			194.4917							
			122521			40.2							
			M128254			56							
			M129545			36.875							
			M129972			61.4167				129972			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

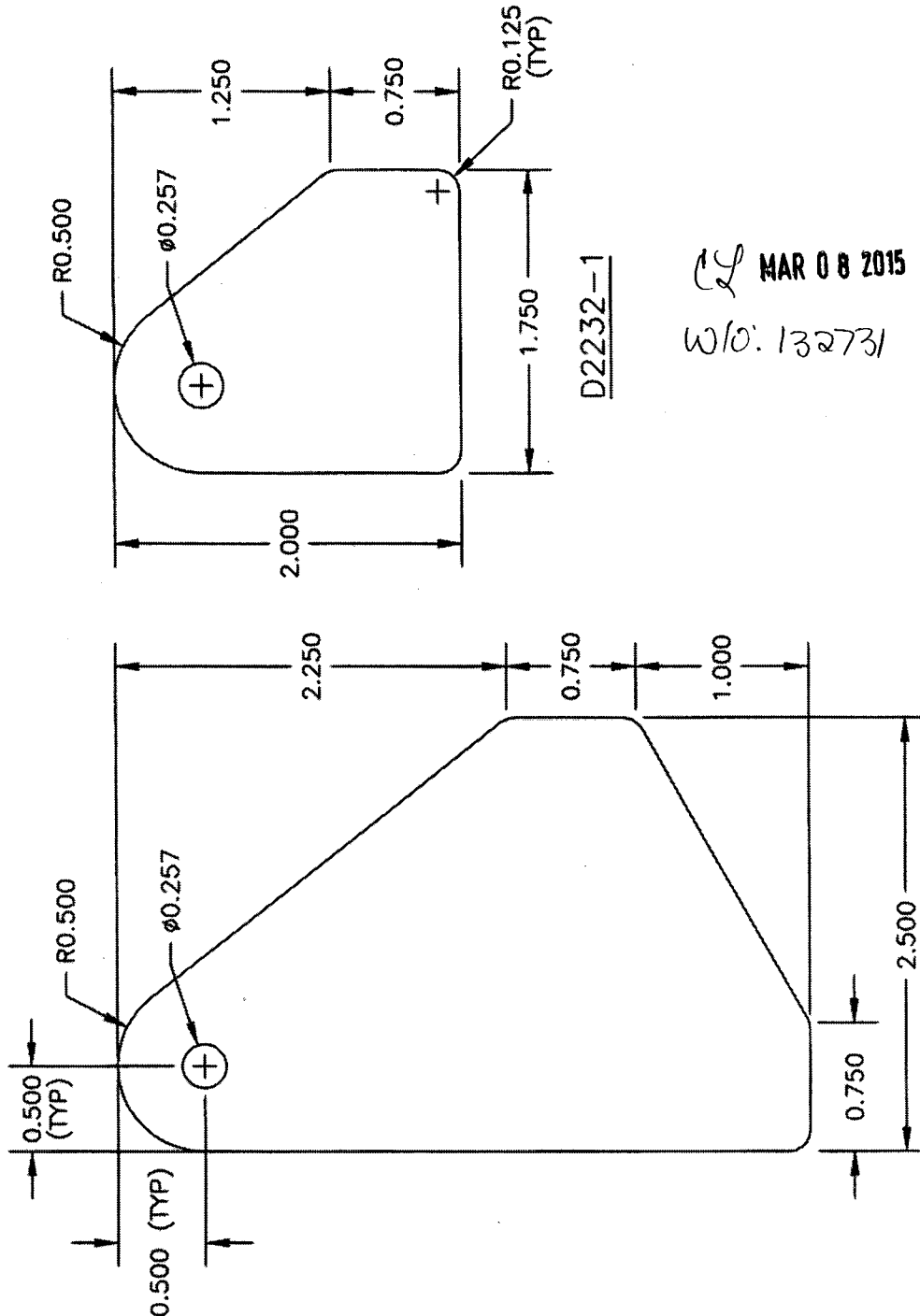
Work Order update only ☐

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OTHER : ☐					



DESIGN	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MA</i>	APPROVED <i>KE</i>	DRAWING NO. D2232	REV. C SHEET 1 OF 2
DATE 98.04.28	TITLE BASKET HINGE		SCALE 1:1
A	94.05.12	NEW ISSUE	
B	96.01.02	ADDED -5 AND -7	
C	98.04.28	0.125 THICK WAS 0.063	

RELEASED
98.05.05 KE



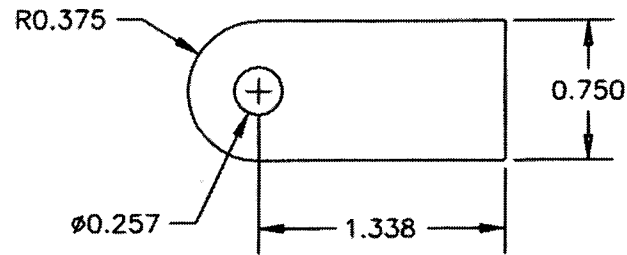
CL MAR 08 2015
W/O: 132731

MATERIAL: AISI 304/316 SS 0.125 THICK

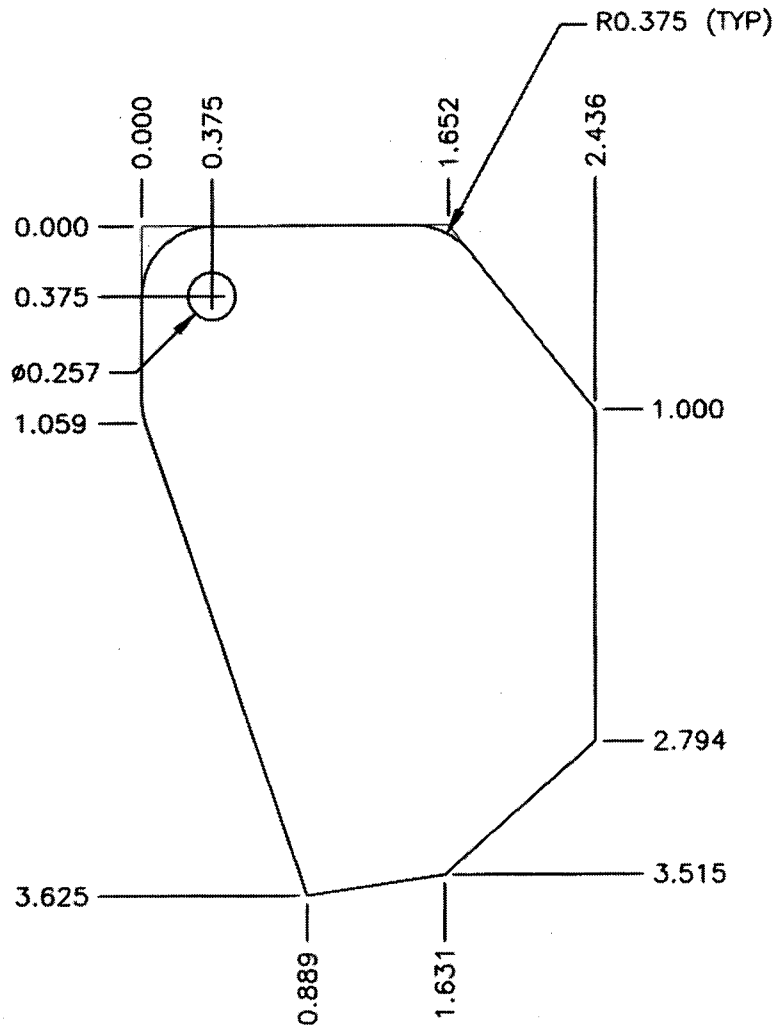


DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	TITLE	SHEET 2 OF 2
98.04.28	D2232	BASKET HINGE	SCALE
			1:1

RELEASED
98.05.05 KE



D2232-7



D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

